

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029847**Date Inspected:** 15-Jul-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** USA Hoist**Location:** Crest Hill, IL.**CWI Name:** None present this day**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Elevator items**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) arrived at the USA Hoist production facility for the purpose of performing inspections of Tower Elevator items to the requirements CC0-085, Standard Specification and Special Provisions.

The welding was performed and completed this day of 1/2" longitudinal stiffeners and of 3/8" radial gusset stiffeners for the Safety Mounting Plate per drawing 916250-11. The welding was performed by Manola Lunas #B utilizing Kobe Steel brand 'Familiarc' E71T-1M .045" diameter FCAW-G electrode as per AWS A5.20, D1.1 and the approved WPS# FCAW3210. The shielding gas used was a mix of Argon 75%/CO2 25% with a flow rate of 38CFH. The welds performed of these completed members appear to meet the requirements of the contract documents.

This QAI received the C.O.C.s for Bearing & Roller Mounting Plates (4 total) and Tower Masts #48-51 (4LH/4RH, 8pcs. total) from Tim Moran, with QC welding inspection reports attached. A verification inspection was performed of the members and they appeared to meet the requirements of the contract documents. Green-Tag packages Lots #B360-015-13 and #B360-016-13 respectively, were generated and attached to each load for release.

WELDING INSPECTION REPORT

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CERTIFICATE OF COMPLIANCE
For Contract # 66010-SC-010

I certify that the material listed below complies with the material and workmanship requirements of Contract Plans, Special Provisions, Standard Specifications, Standard Plans and USA Host drawings.

I also certify that I am an official representative for USA Host Co. and that the material listed below is for the use of the project listed below. Furthermore, I certify that where California Test methods are part of the specifications, the manufacturer has performed the necessary quality control to substantiate this certification.

MATERIAL DESCRIPTION

USA Host Purchase Order: 11-2609-NA
Manufacturer: USA Host
Model/Drawing No: 94203 - Tower Mast Section # 48 (8x51)
Serial Number (if applicable): NA
Test Quantity to be supplied: 4
Remarks: Tower section ready for machining (48-51) 4p Tower's Machining

Signed by: *Tim Moran*
Printed Name: Tim Moran
Title: Project Manager
Company: USA Host
Date: 07/15/2013

STATE OF CALIFORNIA STOCK MATERIAL
LOT NO. 6560-016-13
INSPECTOR'S NAME: *W/M/M*
DATE: 7-15-2013

Signed by: *Tim Moran*
Printed Name: Tim Moran
Title: Project Manager
Company: USA Host
Date: 07/15/2013

STATE OF CALIFORNIA STOCK MATERIAL
(8 PCS) TOWER ELEVATOR MASTS 48-51
LOT NO. 6560-016-13
INSPECTOR'S NAME: *W/M/M*
DATE: 7-15-2013

AUTHORIZED STATE PERSONNEL ONLY



Summary of Conversations:

This QAI informed Tim Moran that above-mentioned items were Green-Tagged and ready to ship.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

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Inspected By: Morris, Monty

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer